

Deliv 54430

Work Order ID 52795

October 14, 2009 10:45:47 AM



Item ID: D3391-025	Accept		Setup	Start	
Revision ID: H				Stop	
Item Name: Aft Tube Assembly					
Start Date: 14/10/2009	Start Qty: 1.00		Cust Item ID:		
Required Date: 02/11/2009	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 09-10-14	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: H

Q.M. 09 - 10 - 27

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Q.M. 09 - 10 - 27

111

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 805/10/28

40 /

Work Order ID 52795

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Page 2

Item ID: D3391-025

Accept

Revision ID: H

Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA 599 Rev: H & Dwg D3391 Rev: H SL 09/11/15
2-Deburr

0.00

0.00

1	0		
---	---	--	--

130



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SL 09/11/15

1	0		
---	---	--	--

140



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

OK 09/11/18






1	0		
---	---	--	--



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Item ID: D3391-025 Accept  Setup Start 
Revision ID: H Stop 
Item Name: Aft Tube Assembly
Start Date: 14/10/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 02/11/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							 09-11-17
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160  CNC Bend 1	BENDING MACHINE - SKIDTUBES	0.00							1 09/11/20
CNC Delta 100 Bender	Memo	0.00							
	Form as per Dwg D3391 Using Bend Prog 3391025								
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							 9-11-20

Work Order ID 52795

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Item ID: D3391-025

Accept



Setup Start

Revision ID: H²

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

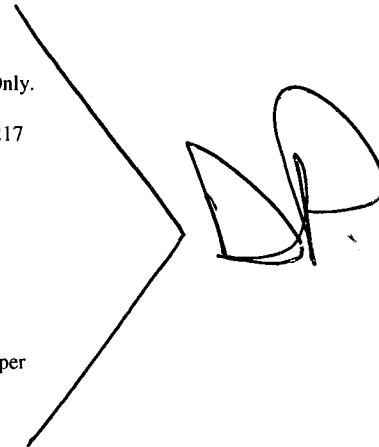


QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per.DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								



9-11-20

Abstract

October 14, 2009 10:45:47 AM

Accept

**Setup Start**

Stop.

Start Date: 14/10/2009 **Start Qty:** 1.00
Required Date: 02/11/2009 **Req'd Qty:** 1.00






Cust Item ID:
Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				<u>78</u>	<u>6</u>		
200 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							9/11/20
210 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				<u>1</u>		119/11/20	

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Item ID:	D3391-025	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Aft Tube Assembly					
Start Date:	14/10/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	02/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 	Skidtubes	0.00				1	419	11/120	
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>M112417</u> exp. date: <u>12/5/8</u> cure time 12hrs as per QSI0015								
230 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
240 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>1:45</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>2:15</u>								

27 8 on 12/01

BR 09-12-01

(X)

D.

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Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	=> M 09/12/01			(X1)	Q		
260 HandFinish Hand Finishing	HandFinishing Memo ✓ 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 7 A/R Sikaflex-241/-291 M112345 Sikaflex expiry date: 10/08	0.00 0.00	M 09/12/01			(X1)	Q		
270 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> S 09/12/02			(X1)	Q		

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Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

u 09/12/01

Memo

0.00

(21)

290



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/12/09 J

u 09.12.09

Picklist Print

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Page 1

Work Order ID: 52795

Parent Item: D3391-025RevH

Parent Item Name: Aft Tube Assembly

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D6014-090RevA Manufactured No



ALUMINUM EXTRUSION

21.0000 1.0000



Q.M. 09-10-27

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

LG

21

42768

21

6

D3670-4-200RevA Manufactured No



SPACER

230 Each 163.0000 4.0000



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST

163

46106

4

47122

32

48198

42

48269

85

4

49/11/20

Picklist Print

October 14, 2009 10:45:56 AM

Work Order ID: 52795



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC		Manufactured	No			270	Each	55.0000	1.0000			
Aft Cap												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

B52663

55

20208

0

43801

1

46327

6

48109

48

(X1)

88 09/12/01

D3537-1RevC

Manufactured No



270

Each

199.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

162

51678

162

Main Warehouse

ST

35

51918

35

(X1)

81 09/12/01

Picklist Print

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Work Order ID: 52795



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-7RevC		Manufactured	No			270	Each	23.0000	1.0000			



Wearpad

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

23

45408

9

46346

14

D3553-1RevA

Manufactured

No

270

Each

18.0000

1.0000



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

18

33868

18

D3553-3RevA

Manufactured

No

270

Each

7.0000

1.0000



Gasket

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

7

47206

7

(X1) JH 09/12/01

(X1) JH 09/12/01

(X1) JH 09/12/01

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Shop Packet Print

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Picklist Print

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Work Order ID: 52795



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly


Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB  Phenolic Washer		Manufactured	No			270	Each	2,060.000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1560	
39275	19	
42329	19	
47628	522	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

(x2) 9/12/01

ALS4-1032-130

Purchased

No

260

Each

5,373.000

14.0000



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5373	
110511	5373	

M111529

(x14) 9/12/01

Picklist Print

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Work Order ID: 52795



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			270	Each	7,911.000	12.0000			

Insert

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

7911

107441

16

10768

7895

(X12) 09/12/01

AN3C4A

Purchased

No

270

Each

2,216.000 6.0000



BOLT

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2216

112082

14

112314

40

112720

162

112724

500

112794

1000

112829

500

M113121

(X6) 09/12/01

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Shop Packet Print

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Picklist Print

Page 6

October 14, 2009 10:45:56 AM

Work Order ID: 52795



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A 		Purchased	No			270	Each	718.0000	4.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	718	
111424	8	
111707	69	
112314	11	
112489	100	
112641	500	
112720	30	

(X4) 09/12/01

AN960C10L



washer

Purchased

No

270

Each

4,772.000 10.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4672	
112116	1009	
112612	3663	

M 112933

(X10) 09/12/01

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Shop Packet Print

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DART AEROSPACE LTD		Work Order: 52795
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.500	✓			
88.93	+/-0.030	88.945	✓			
44.995	+/-0.030	44.965	✓			
Ø3.200	+/-0.010	3.200	✓			
88.93	+/-0.030	88.945	✓			
Ø3.750	+/-0.010	3.751	✓			
30° x 160° chamfer	+/-0.010	30° x 160°	✓			

Measured by: <i>Qm</i>	Date: 09-10-27
Audited by: <i>Qm</i>	Date: 09/10/28

HAAS Section						
1.526	+0.000/-0.030	1.515	✓			
0.200	+/-0.010	.203	✓			
7.500	+/-0.010	7.491	✓			
27.750	+/-0.010	27.741	✓			
31.750	+/-0.010	31.741	✓			
35.250	+/-0.010	35.241	✓			
3.300	+/-0.010	3.305	✓			
0.200	+/-0.010	.208	✓			
3.520	+/-0.010	3.529	✓			
0.687	+0.010/-0.000	.690	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.485	✓			

Measured by: <i>SL</i>	Date: 09/11/15
Audited by: <i>Qm</i>	Date: 09/11/18

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	Ø.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	<i>Qm</i>

SHOP COPY
RETURN TO
ENGINEERING 1

UNCONTROLLED COPY

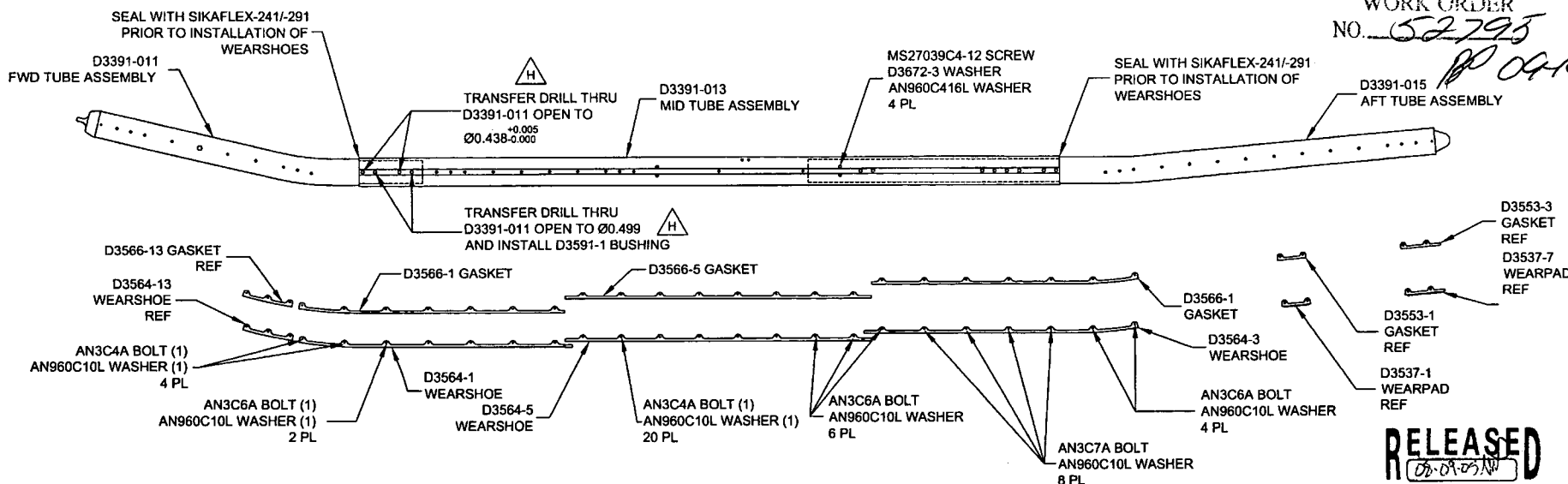
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 52795

09-10-14



D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

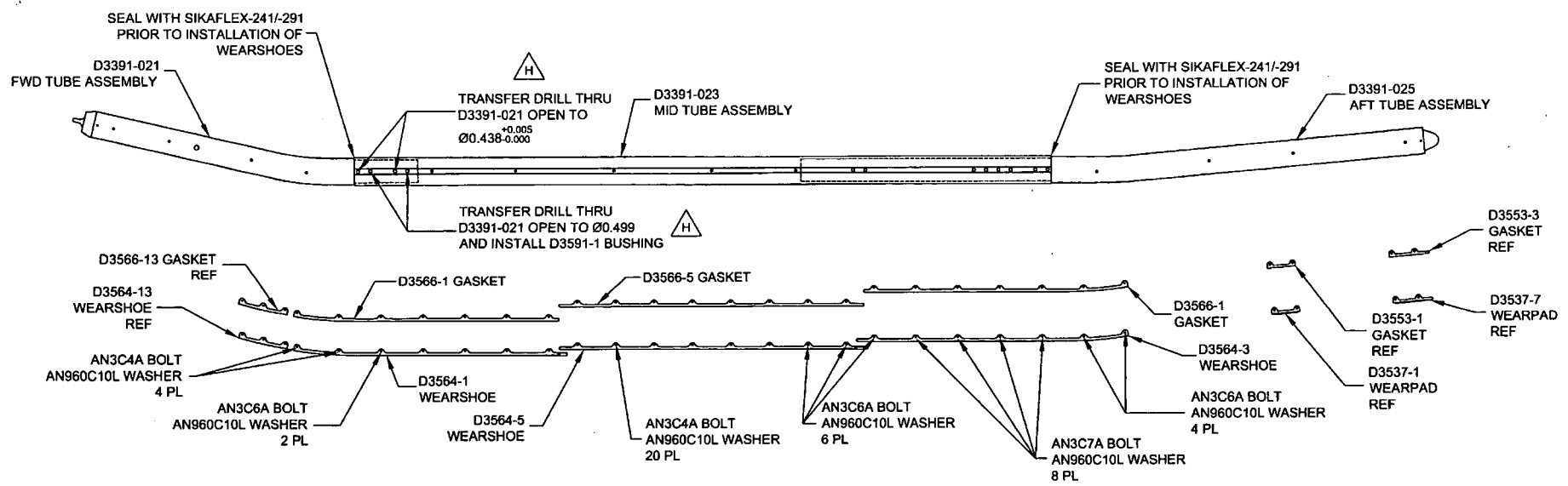
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC			

W/O 52795



D3391-043 ASSEMBLY





D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
2	D3561-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

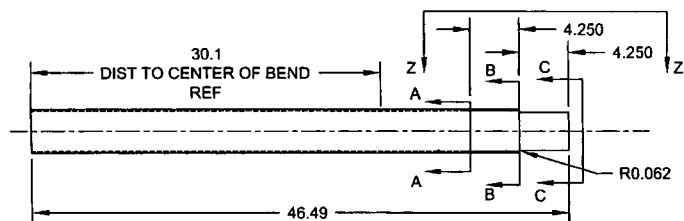
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

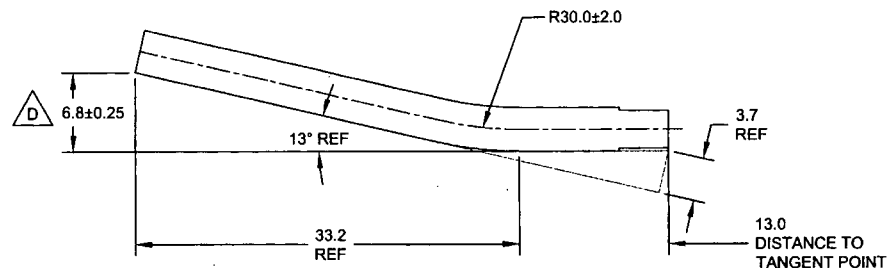
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MFG. APPR.		D3391	SHEET 2 OF 8
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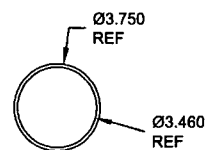
u/o 52795



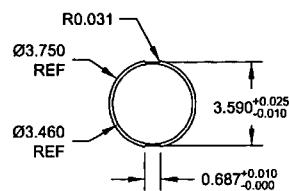
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



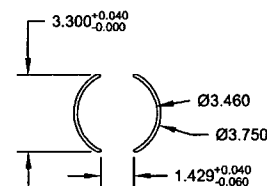
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



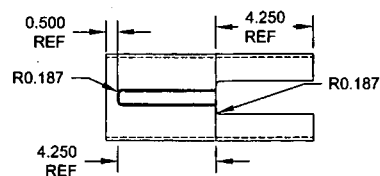
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

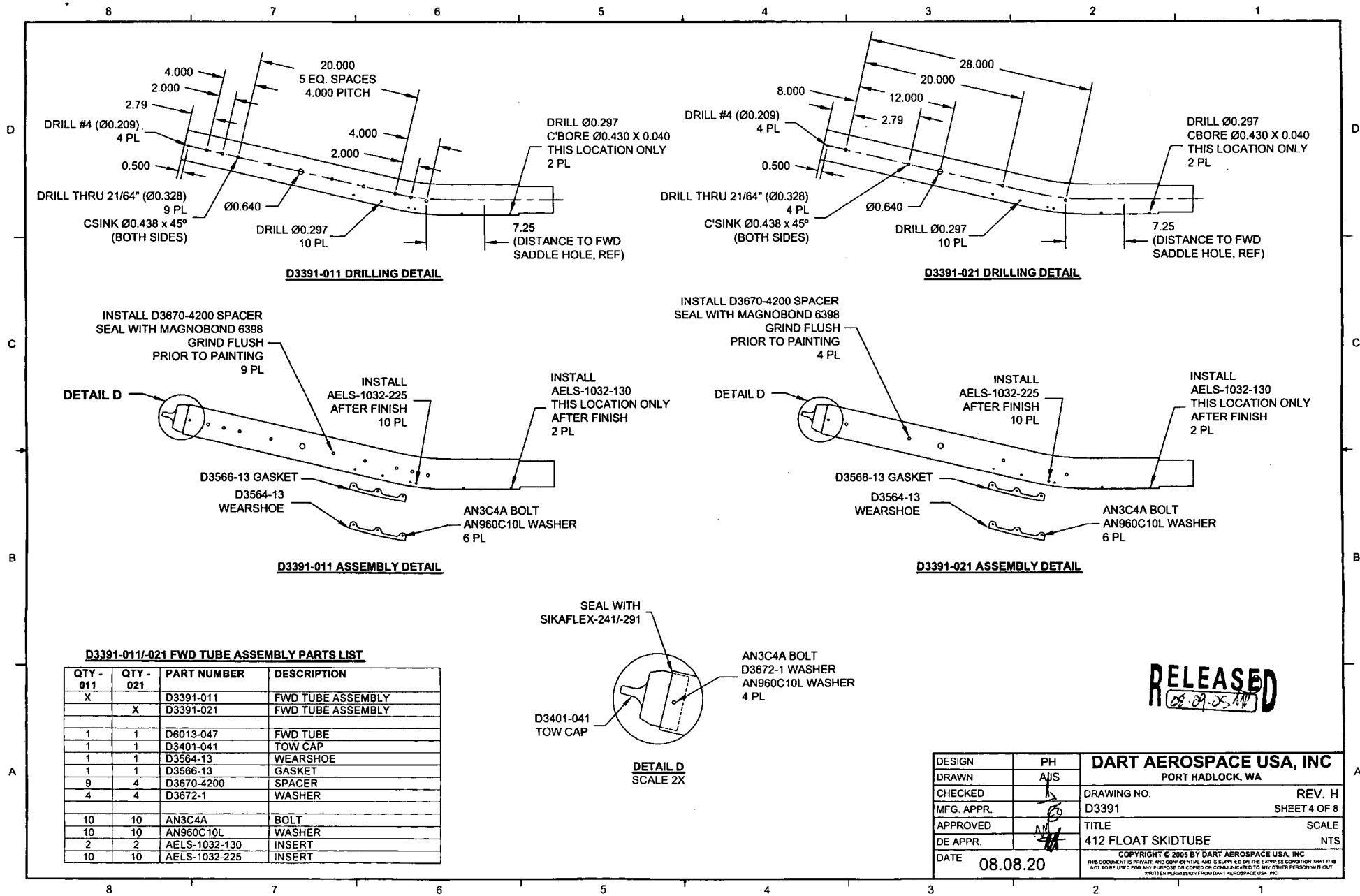


VIEW Z-Z
SCALE 2X

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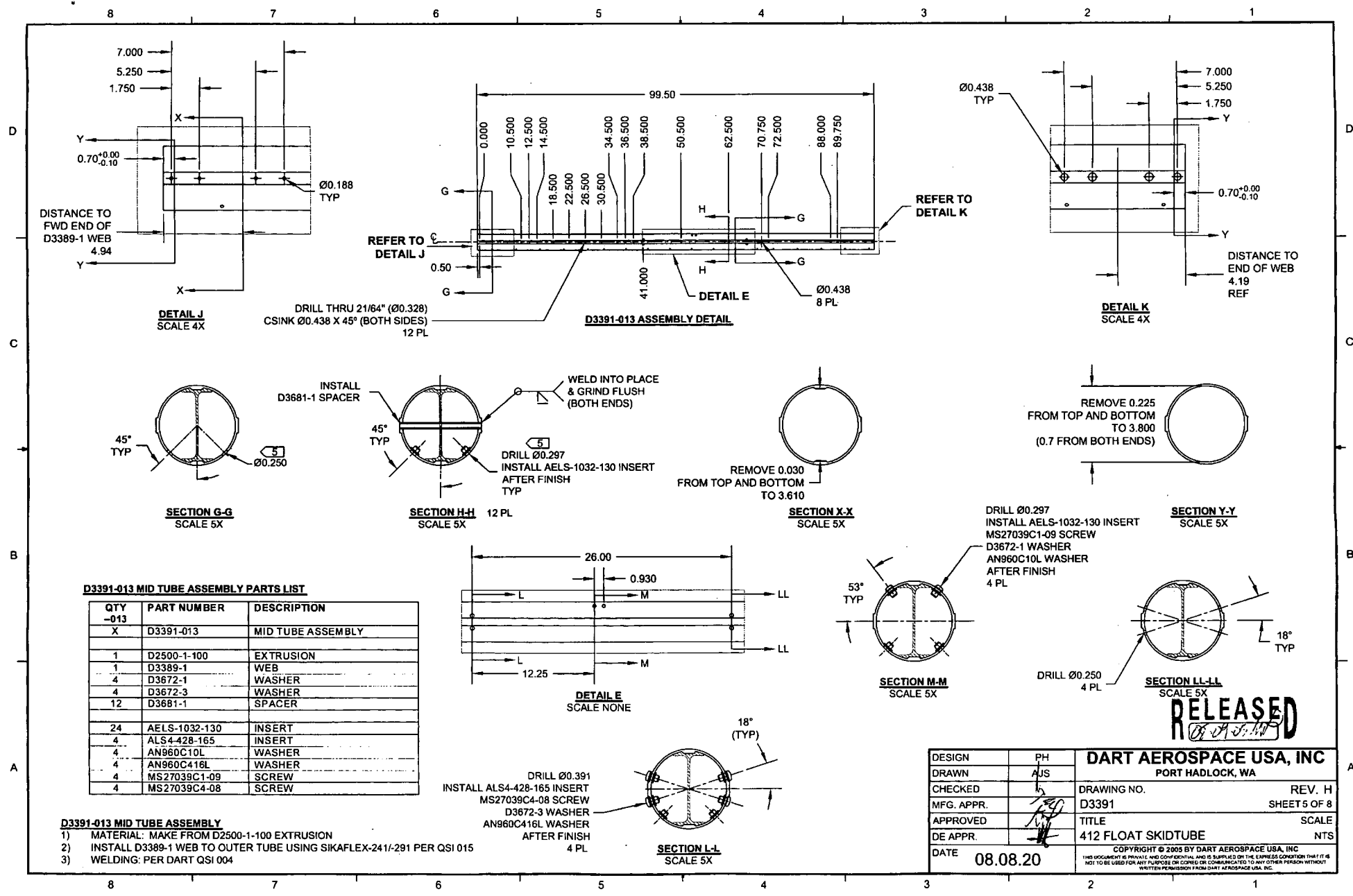
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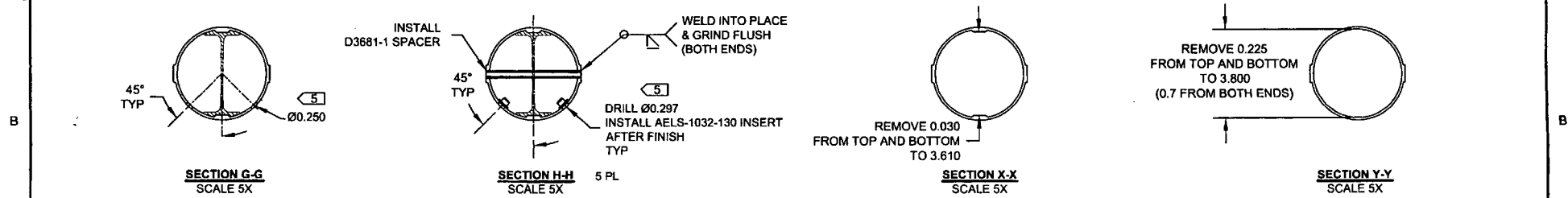
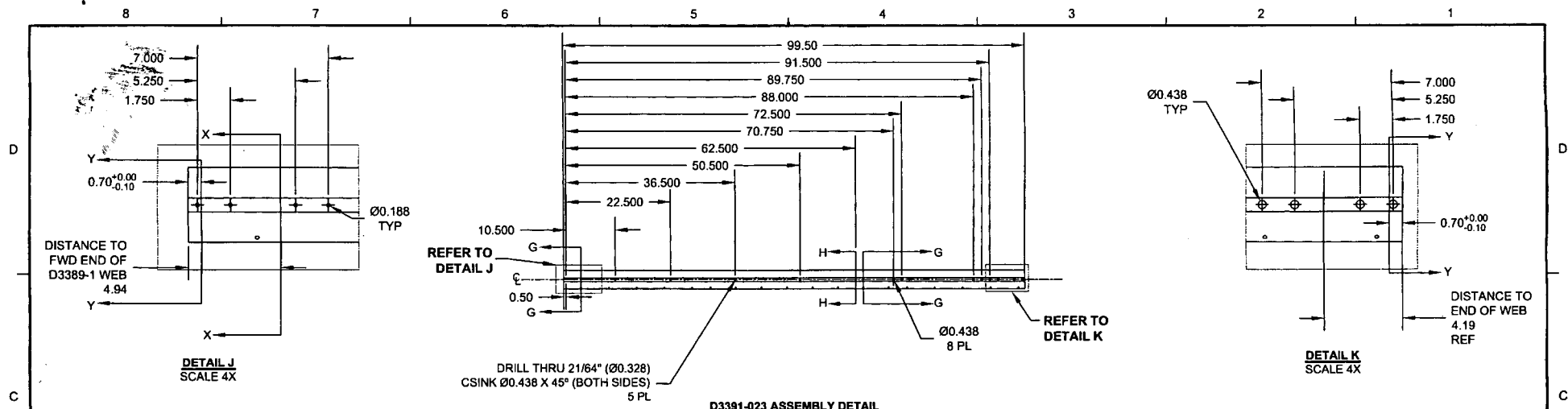
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D3391-023 MID TUBE ASSEMBLY PARTS LIST

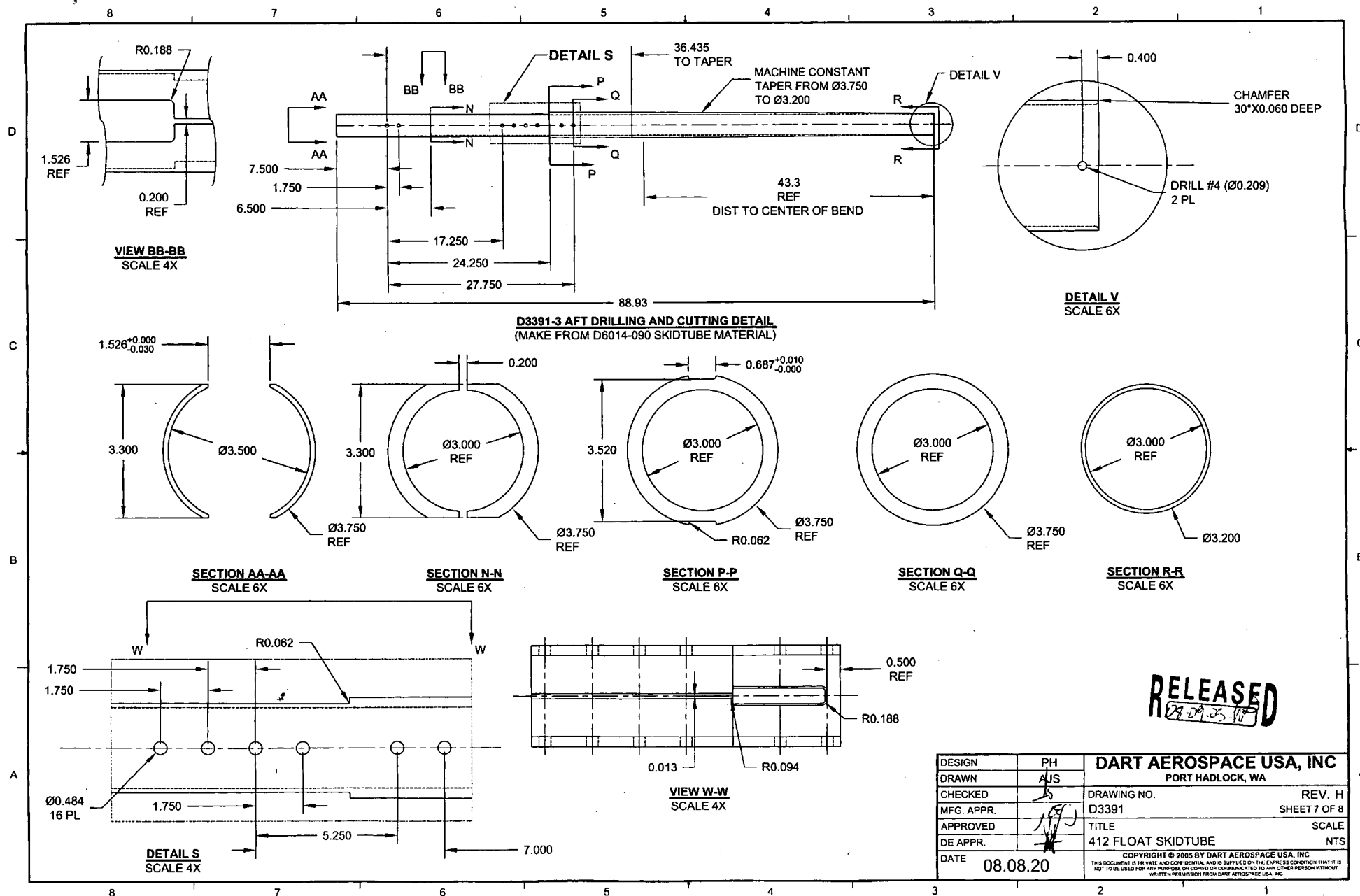
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

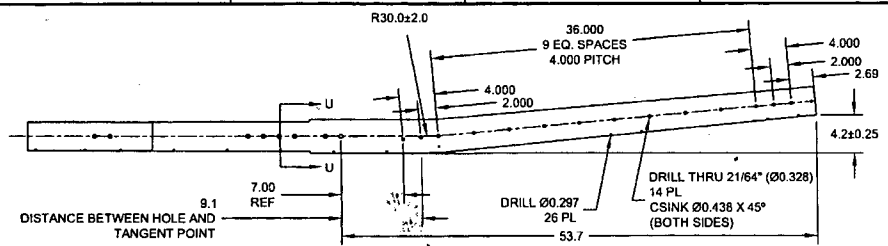
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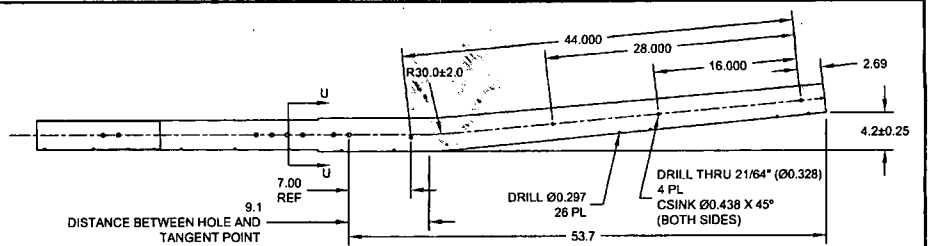
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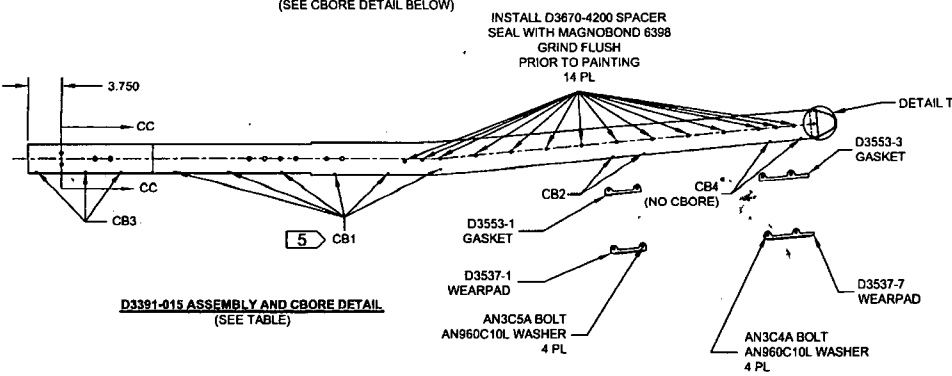
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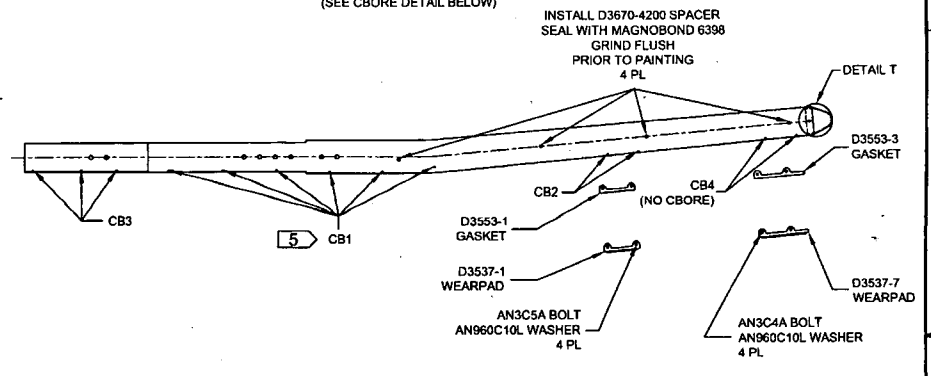
D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



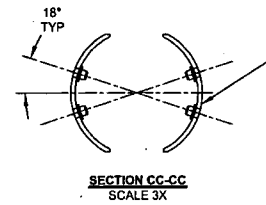
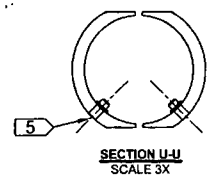
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



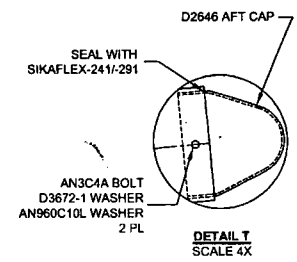
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS-428-165 INSERT
4 PL



RELEASED
08-09-05-147

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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